

Work Order ID 85141

June-04-12 1:26:47 PM

\*85141\*

Page 1

Item ID: D350-636-012

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Start Date: 04/06/2012 Start Qty: 1.00 \*1\*

Required Date: 18/06/2012 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

20/06/2012

DC

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

JB

MLJ 12/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D350-636-012

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 04/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

\*110\*

Skidtubes

Memo

1- Pick D2600-3 Bent

8E 12/06/25

0.00

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D2750

8E 12/06/25

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
debur.

✓

3 SAD 12-06-28

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade  
fitting

✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

8E 12/06/25

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

3 SAD 12-06-28

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail "K" to 0.375" (4 holes per side)and blade fitting  
location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up  
holes for ground handling and detail L to 0.500" (8 holes per side)

3 SAD 12-06-28

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297".

3 BB 12/06/28

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

W/O:		WORK ORDER CHANGES							
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**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
Description11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: M122430

12-Grind welds flush as per Dwg D2750

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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*78E 12/06/25*

120

**\*120\***

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

*5.7/04/12*

0.00

130

**\*130\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

*5.7/04/12*

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Skidtube RH

Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

140

**\*140\***

HandFinish

Hand Finishing

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

1 7/12/13

150

**\*150\***

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

0.00

Memo

0.00

① 500 12-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 11		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**\*NS1\***

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Item Name: Skidtube RH

Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

160

**\*160\***

Skidtubes

Operation  
Description

Skidtubes

Set Up/  
Run Hours  
0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Skidtubes

Memo 0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 121409  
exp. date: 0-4-12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M12260

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

SAD 12-07-03

-DC 12/07/03

78E 12/07/05

78E 12/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Item ID: D350-636-012

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

/ 7/6 1279

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*200\***

Powdercoat

Powder Coating

Memo

START TIME: 9:30 0.00  
OVEN TEMPERATURE: 3200  
FINISH TIME: 10:001X ✓ M 12/07/09

210 QC3- Inspect Part Finish 0.00

**\*210\***

QC

Quality Control

Memo

✓ Inspect for foreign object per QSI 024

✓ ✓ 12/10/10

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

**Work Order ID 85141**

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Item ID: D350-636-012

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

230

**\*230\***

HandFinish

Hand Finishing

Operation  
Description

HandFinishing

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

VRH 6 11/02/10

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"  
batch: NR44-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750

SIKA FLEX 241

BATCH: 11121409EXP DATE: 11/155-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 1111803486-Coat all exposed fasteners with "LPS Procyon"  
batch: 11114596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-012

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Revision ID:

Item Name: Skidtube RH

Start Date: 04/06/2012 Start Qty: 1.00 **\*1\***Required Date: 18/06/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

240

**\*240\***

QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/  
Run Hours

0.00

5/2/12/11

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

**\*250\***

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

*5/2/11* 

260

**\*260\***

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

*DAS  
16  
5-09* *5/2/12**Q*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 85141

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Item ID: D350-636-012

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 04/06/2012 Start Qty: 1.00 \*1\*

Required Date: 18/06/2012 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

270

\*270\*

Packaging

Operation  
Description

Packaging

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Packaging

Memo

0.00

280

QC21- Final Inspection - Work Order Release

0.00

\*280\*

QC

Quality Control

Memo

0.00

MLJ 12/07/13

MLJ 12/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Picklist Print**

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Work Order ID: 85141

**\*85141\***  
**\*D350-636-012\***

Parent Item: D350-636-012  
Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

**Comments:**

IPP Rev:I02.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	29.0000	1	1	**		

**\*D2600-3-BFNT\***

Extrusion Bent

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	29	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
83442	13	

D2744

Manufactured No

110 Each 35.0000

1

1

**\*D2744\***

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG002	35	
62715	1	
78900	3	
83412	31	

*8/6/06/25**8/12/06/25*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*85141\*  
\*D350-636-012\*

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No 160 Each 13.0000 1 1 \*\*

\*D2739\*

350 I Beam

DC 12/07/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	13	1
72155	1	
81508	1	
83447	4	
83448	5	
83548	2	

D2743

Manufactured No 160 Each 296.0000 8 8 \*\*

\*D2743\*

Crossbolt Spacer

86 12/07/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	222	
81965	55	
83262	167	8
LG001	74	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	

D3490-3

Manufactured No 160 Each 46.0000 4 4 \*\*

\*D3490-3\*

Cross Bolt Spacer

86 12/07/05

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	46	
83313	46	4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID:** 85141**Parent Item:** D350-636-012**Parent Item Name:** Skidtube,RH**\*85141\***  
**\*D350-636-012\*****Start Date:** 04/06/2012**Start Qty:** 1.00**Required Date:** 18/06/2012**Required Qty:** 1.00

D3490-1

Manufactured No

160 Each 45.0000 4 4

**\*\*****\*D3490-1\***

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	2	
81976	2	
LG001	43	
62450	2	
74875	4	
77042	3	
83269	34	

BE 626705  
B 85419 4

D3631-1

Manufactured No

230 Each 347.0000 8 8

**\*\*****\*D3631-1\***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	332	
81874	2	
83588	330	
ST072	15	
68062	2	
75548	13	

Hd 120710

D3791-1

Manufactured No

230 Each 17.0000 1 1

**\*\*****\*D3791-1\***

Wearplate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	17	
62239	2	
83392	15	

Hd 120710

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

28.0000

1

1

\*\*

HL

12/07/10

\*D3793-3\*

Wearshoe

Location	Loc Qty	Loc Code
----------	---------	----------

FP001	28	
-------	----	--

83394	16	
-------	----	--

83901	12	
-------	----	--

MS21043-6

Purchased No

230

Each

618.0000

4

4

\*\*

HL

12/07/10

\*MS21043-6\*

NUT

Location	Loc Qty	Loc Code
----------	---------	----------

FG	20	
----	----	--

103693	20	
--------	----	--

ST301	598	
-------	-----	--

117887	2	
--------	---	--

118384	96	
--------	----	--

120308	500	
--------	-----	--

D3794-1

Manufactured No

230

Each

26.0000

1

1

\*\*

HL

12/07/10

\*D3794-1\*

Gasket

Location	Loc Qty	Loc Code
----------	---------	----------

FP	6	
----	---	--

82167	6	
-------	---	--

FP002	20	
-------	----	--

83395	20	
-------	----	--

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*85141\***  
**\*D350-636-012\***

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

188.0000

8

8

\*\*

8

**\*NAS1611-010\***

O-RING

110710

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	188	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
121259	2	
121415	4	
121584	59	
<u>121723</u>	50	

D2741

Manufactured

No

250

Each

20.0000

1

1

\*\*

83135 ✓ J B 12/07/11

**\*D2741\***

Blade, 350 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	-10	
ST466	30	
71856	1	
79516	19	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*85141\***  
**\*D350-636-012\***

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

NAS1515H3L

**\*NAS1515H3L\***  
WASHER

Purchased

No

230

Each

146.0000

4

4

\*\*

HL

120710

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
102472	40	
ST277	106	
118686	3	
119438	1	X 41
120360	11	
121243	2	
121556	89	

NAS1611-013

**\*NAS1611-013\***  
O-RING

Purchased

No

230

Each

361.0000

8

8

\*\*

HL

120716

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	361	
116582	5	
117291	2	
117887	53	
119623	36	
121584	15	
121825	200	X 8
121826	50	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*85141\***  
**\*D350-636-012\***

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

AN3C6A

Purchased No

230 Each

451.0000

4

\*\*

ML

120710

**\*AN3C6A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	1	
111982	1	
ST351	450	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	158	
<u>121682</u>	200	

NAS1149C0832R

Purchased No

230 Each

257.0000

1

1

\*\*

ML 120710

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST297	257	
<u>114915</u>	257	

D3536-25

Manufactured No

230 Each

28.0000

1

1

\*\*

ML 120710

**\*D3536-25\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	28	
<u>83391</u>	12	
83900	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No 230 Each 23.0000 1 1

\*\*

\*D3794-3\*

Gasket

Location	Loc Qty	Loc Code
FP	21	
83396	21	X1
FP002	2	
74530	2	

AN3C5A

Purchased No 230 Each 1,302.000 34 34

\*\*

\*AN3C5A\*

Bolt

Location	Loc Qty	Loc Code
FP001	7	
115835	7	
ST350	1295	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121068	12	
121255	500	X34
121444	182	
121708	500	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

83 0000

3

3

\*\*

Jul 10 07 10

\*D3537-1\*

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
FG	10	B83256	✓3
79833	10		
FP002	73		
69817	5		
81360	14		
81362	19		
83254	1		
83255	3		
84091	31		

D3535-25

Manufactured No

230

Each

34.0000

1

1

\*\*

Jul 10 07 10

\*D3535-25\*

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
FP001	34		
62233	1		
81357	1		
82156	2	B83099	✓6
83387	17		
83899	13		

D3492-3

Manufactured No

230

Each

167.0000

8

8

\*\*

Jul 10 07 10

\*D3492-3\*

Plug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
FP-A	167		
81967	5		
83099	40		
83529	122		✓8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012  
Start Qty: 1.00  
Required Date: 18/06/2012  
Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No 230 Each 0.0000 38 38

\*AN960C10I \*  
washer

D3488-042 Manufactured No 230 Each 9.0000 1 1

\*D3488-042\*  
Blade Fitting Assembly, RH

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	9	1383412
62003	1	
77015	1	
82258	7	

ALS4-1032-225 Purchased No 230 Each 781.0000 38 38

\*ALS4-1032-225\*  
Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	758	
108696	146	
110768	62	
118386	55	
118966	68	
121269	427	
ST282	23	
120410	10	
120451	13	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

257.0000

8

8

\*\*

all in lot 10

\*D3492-1\*

Plug

Location	Loc Qty	Loc Code
FP002	242	
69531	8	
74444	2	
76235	4	
<u>83259</u>	228	X 8
FP-A	15	
83098	15	

D3793-1

Manufactured No

230

Each

28.0000

1

1

\*\*

all in lot 10

\*D3793-1\*

Wearshoe

Location	Loc Qty	Loc Code
FP001	28	
82171	2	
<u>83393</u>	13	X 1
83903	13	

AN8C35A

\*AN8C35A\*

BOLT

Purchased No

230

Each

68.0000

1

1

\*\*

all in lot 10

Location	Loc Qty	Loc Code
FP002	67	
115960	1	
<u>118286</u>	16	X 1
121275	50	
ST346	1	
114442	0	
115188	0	
115960	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

81.0000

\*\*

1  
1  
1007110

\*MS21083C8\*

NUT

Location	Loc Qty	Loc Code
----------	---------	----------

304	75	
121185	29	
121349	46	
FP002	1	
115884	1	
ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	
ST304	1	
121524	1	

D2745

Manufactured

No

230

Each

122.0000

8

\*\*

1  
1  
1007110

\*D2745\*

Bushing

Location	Loc Qty	Loc Code
----------	---------	----------

FP	6	
79518	6	
FP001	116	
69529	1	
76142	1	
83260	114	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4

\*\*

ML

120710

\*AN6C44A\*

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	2	
103964	2	
ST343	84	
121013	11	
121167	13	
121440	50	XU
121689	10	

D3532-1

Manufactured

No

250

Each

7.0000

2

2

\*\*

83319

✓

12/07/11

\*D3532-1\*

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST053	7	
82041	7	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

**\*85141\***  
**\*D350-636-012\***

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

MS21083C8

Purchased	No	250	Each	81.0000	2	2	✓
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\*\*

JB ~~SO~~

*S* **\*MS21083C8\***  
NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
304	75	
121185	29	
121349	46	121349
FP002	1	
115884	1	
ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	
ST304	1	
121524	1	

NAS1149D0863J

Purchased	No	250	Each	251.0000	2	✓
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JB ~~SO~~ 12/07/11

*S* **\*NAS1149D0863J\***  
WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	251	
118078	34	
119307	17	
120308	100	120308
121556	100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*  
\*D350-636-012\*

Start Date: 04/06/2012

Start Qty: 1.00

Required Date: 18/06/2012

Required Qty: 1.00

D3493-1

Manufactured

No

250

Each

127.0000

2

2

\*\*

\*D3493-1\*

Washer

Location	Loc Qty	Loc Code
ST050	127	
77573	1	
82023	26	
83097	100	

AN8C21A

Purchased

No

250

Each

57.0000

2

2

\*\*

\*AN8C21A\*

BOLT

Location	Loc Qty	Loc Code
ST343	57	
118758	3	
121167	4	
121275	50	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
1			1	D2750-4	SKIDTUBE WELDMENT, RH
	1	1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
	4	4		D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
	8	8		D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

**GENERAL NOTES:**

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 9) WELD PER DART QSI 004
- 10) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (.00.297) FOR WEARSHOE INSERTS  
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL 
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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*66-27-22-14A*

F	INCORPORATE DS1 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1). D3791-1/3 REPLACES D3535-13/35 (ZN C8-1). D3791-1/3 REPLACES D3536-13/35 (ZN B8-1). ADD D3791-1 (ZN C8-1). WEARSHOE HOLES UNDER FWD/AF SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON REF. NCK 08-043	PH	08 07 16
E	CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1. REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741. QTY (2) AN960C816. REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND S/ACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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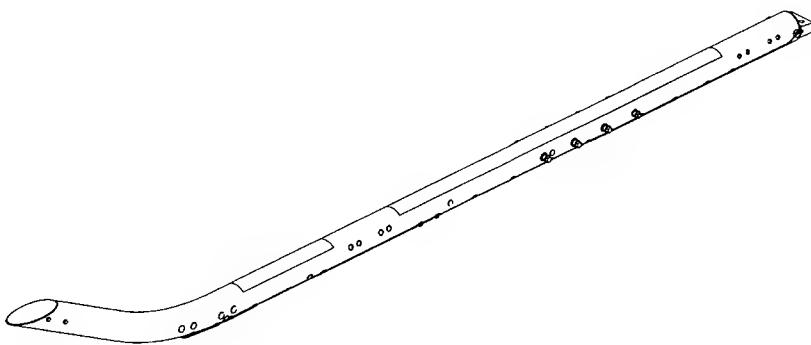
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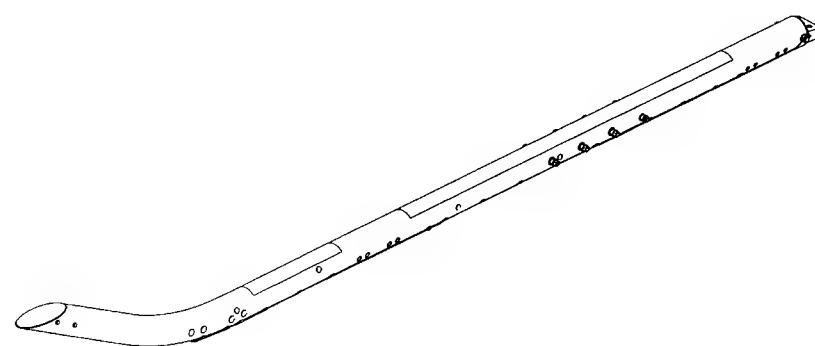
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NOTE: Date & initial all entries

05141



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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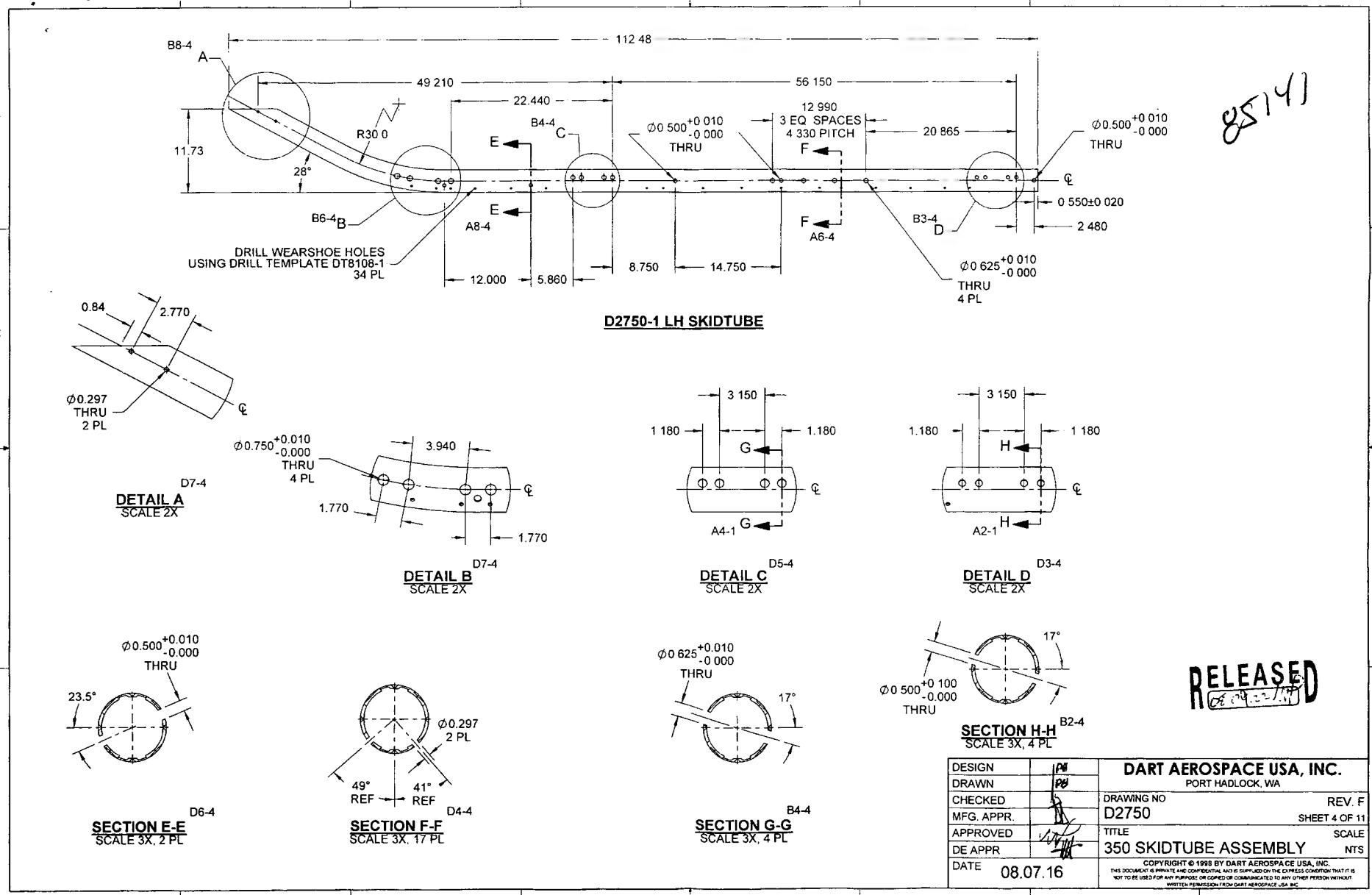
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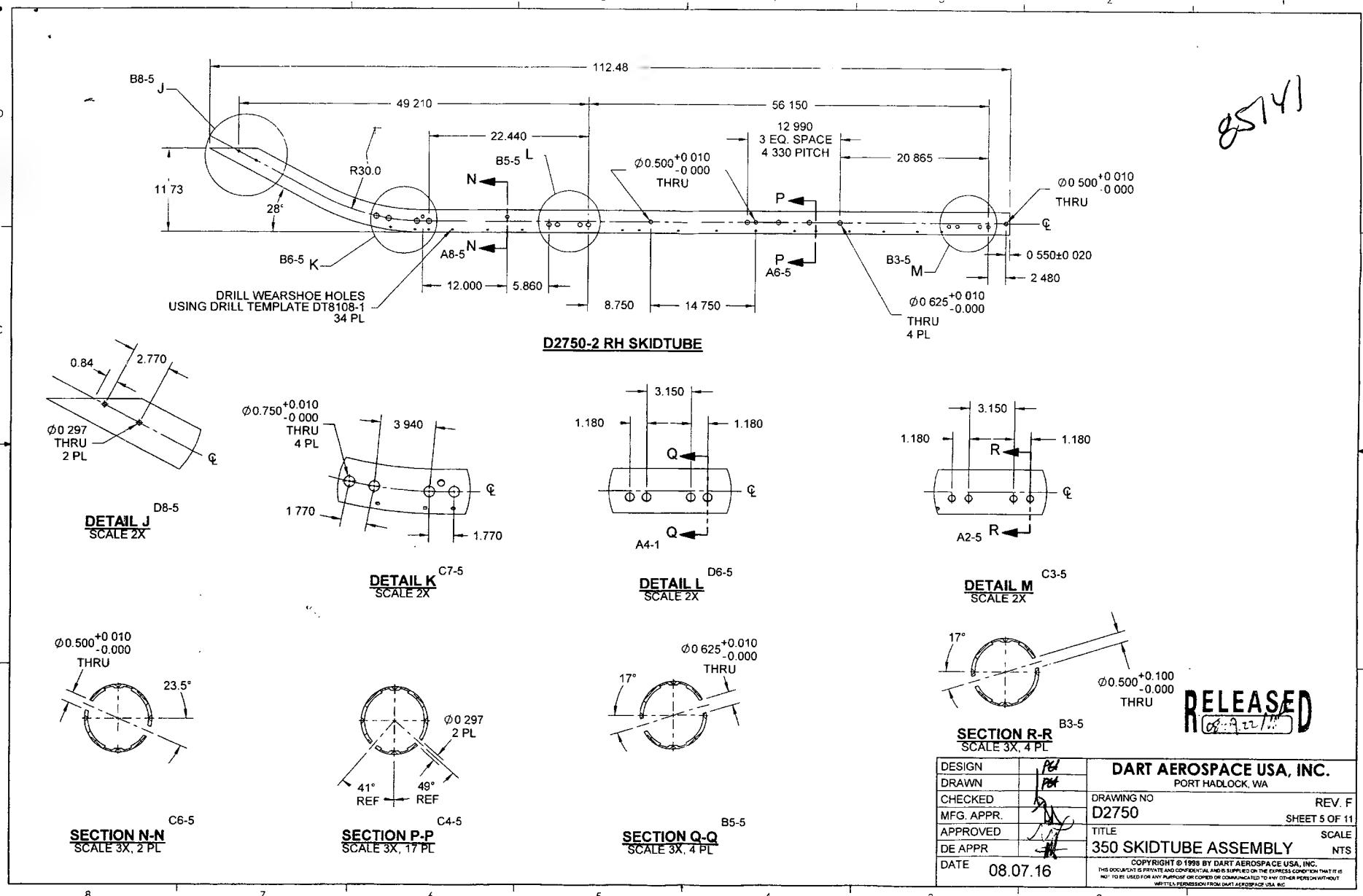
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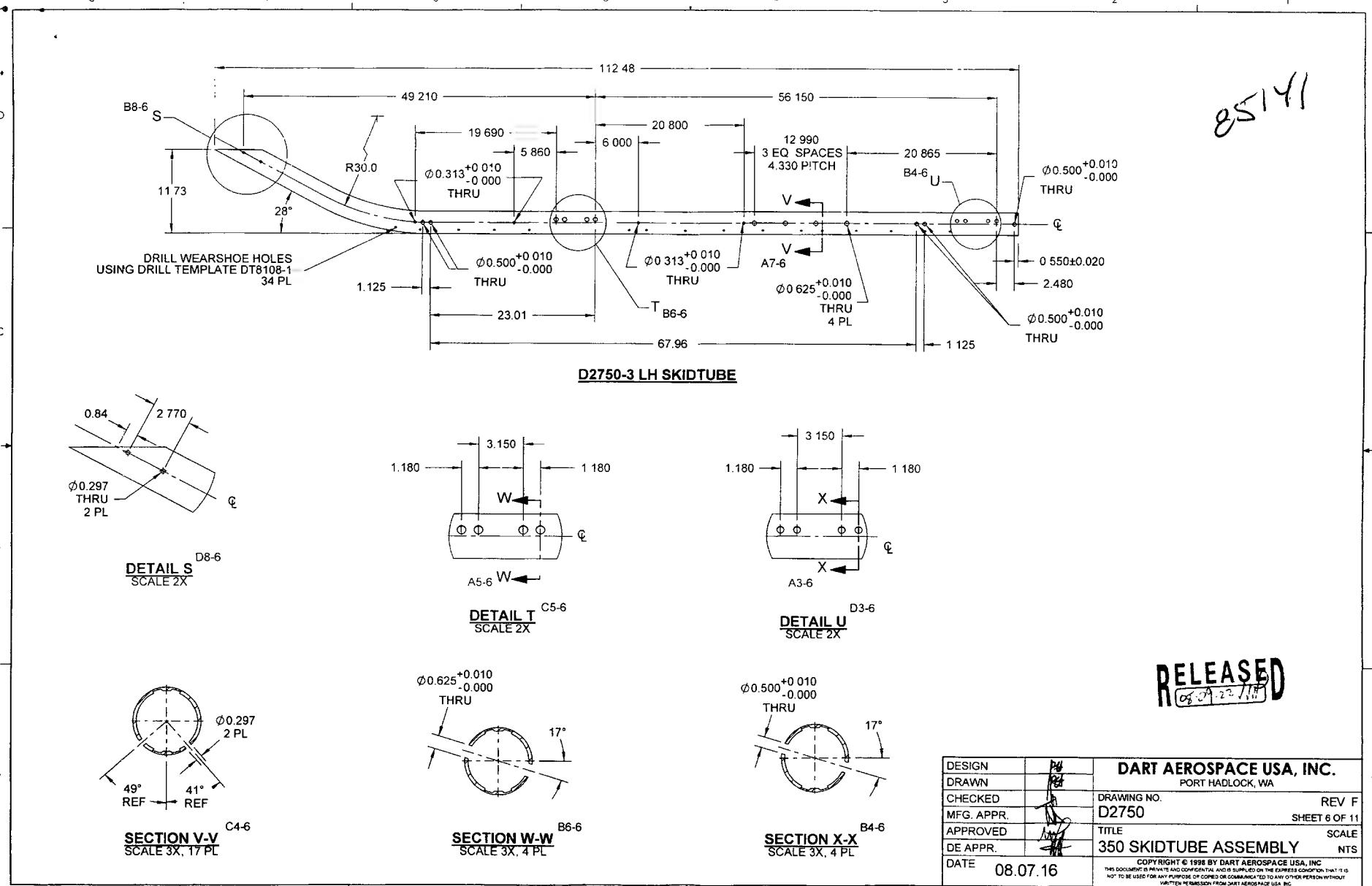
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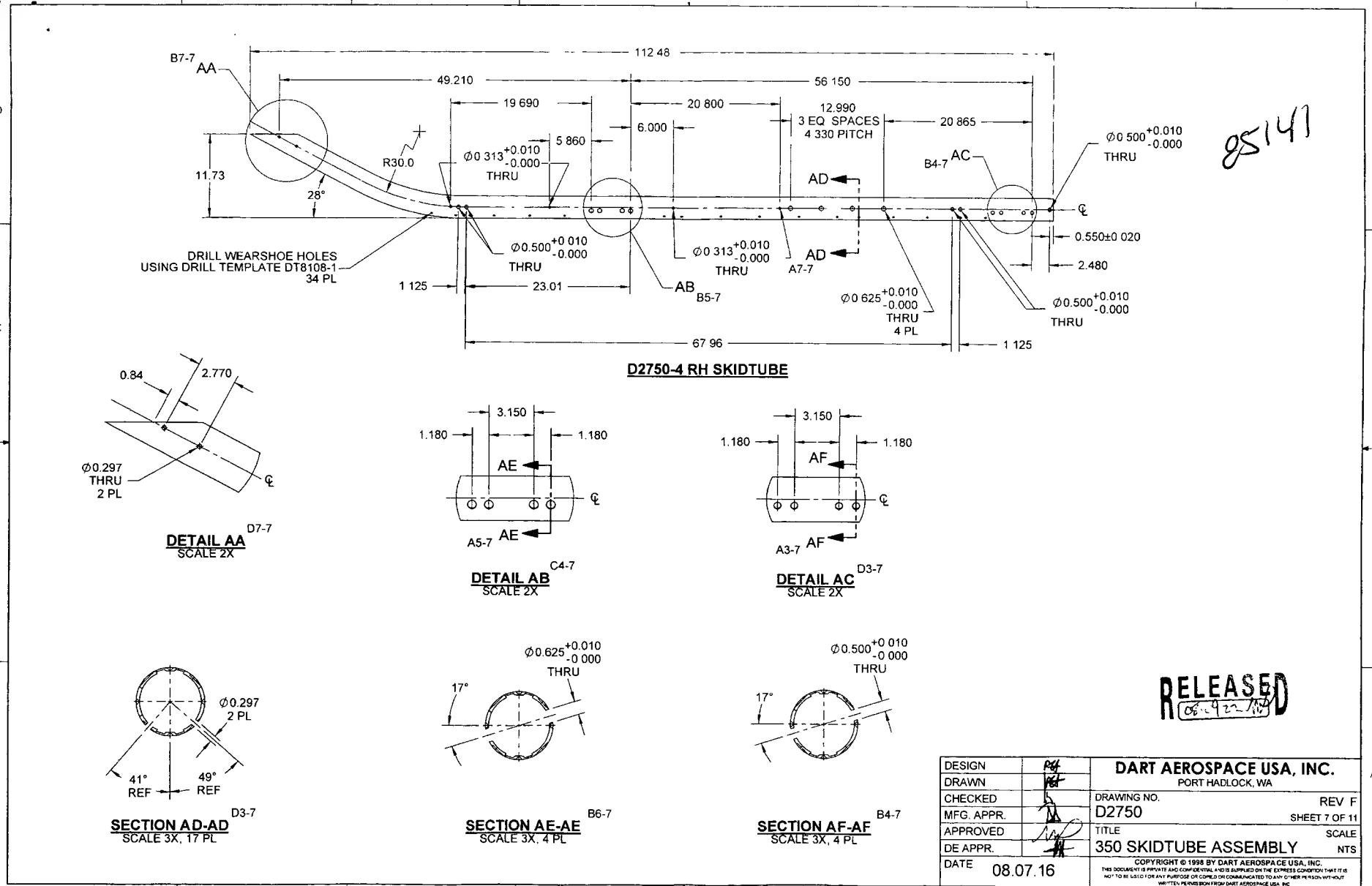
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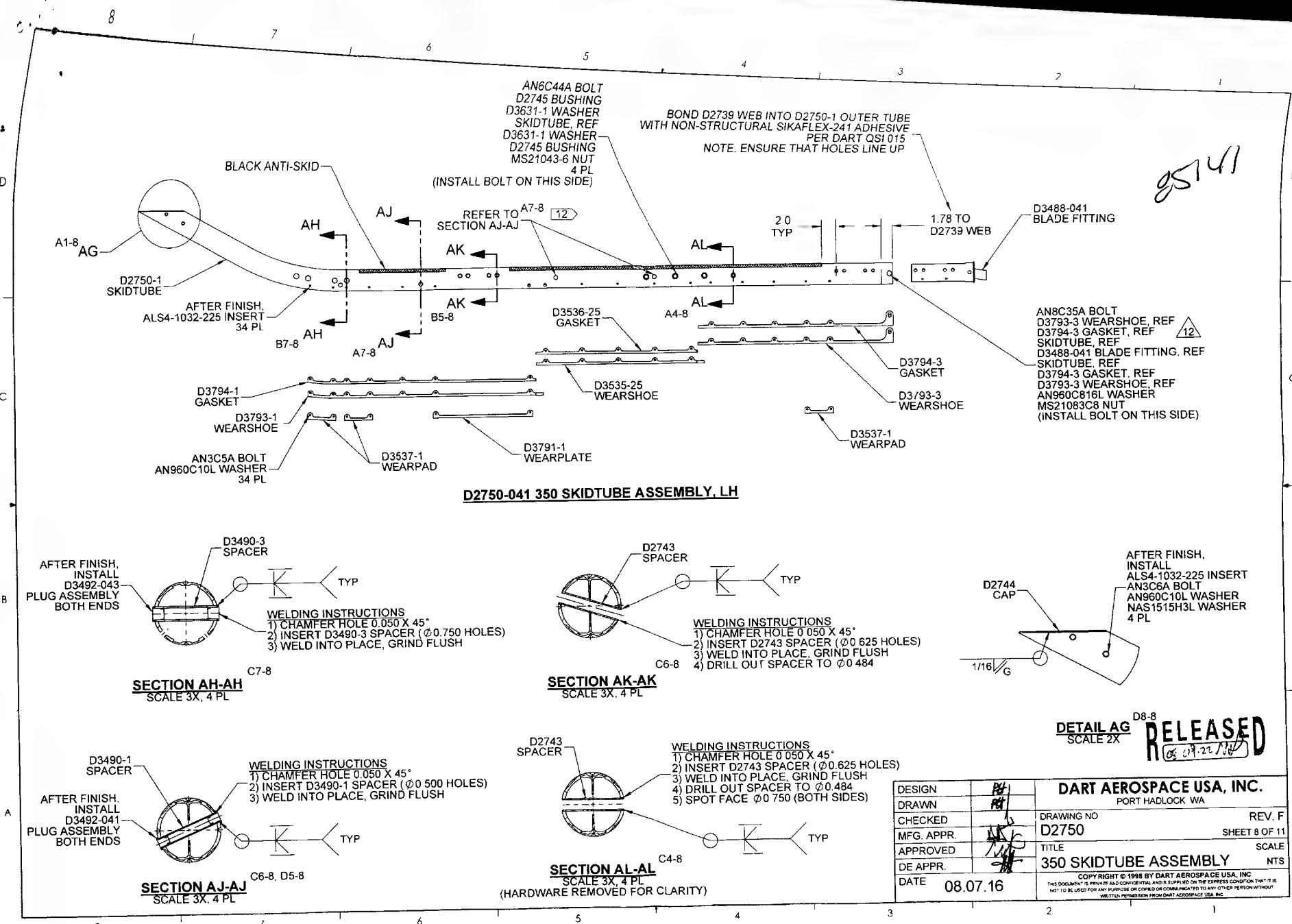
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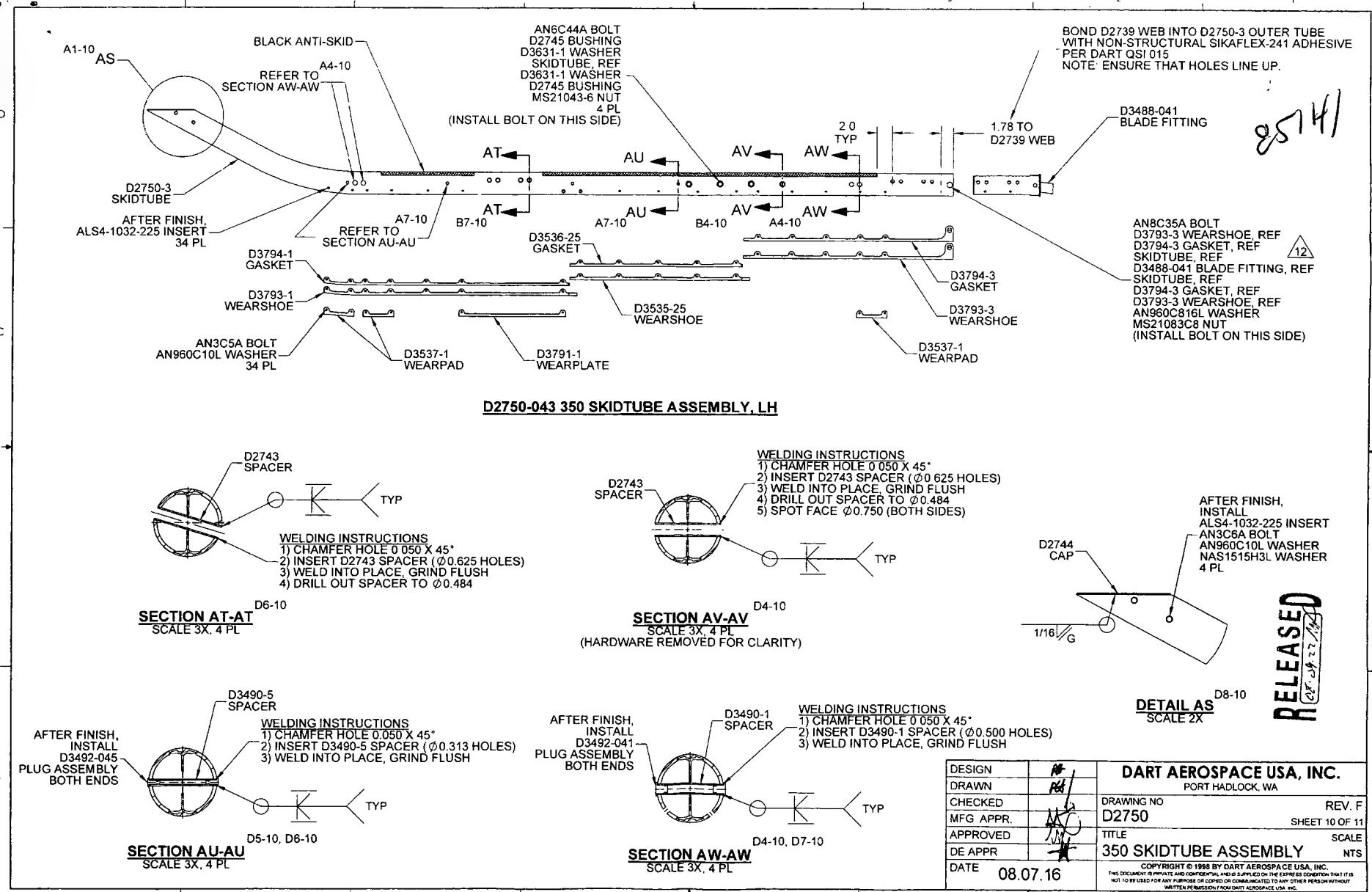
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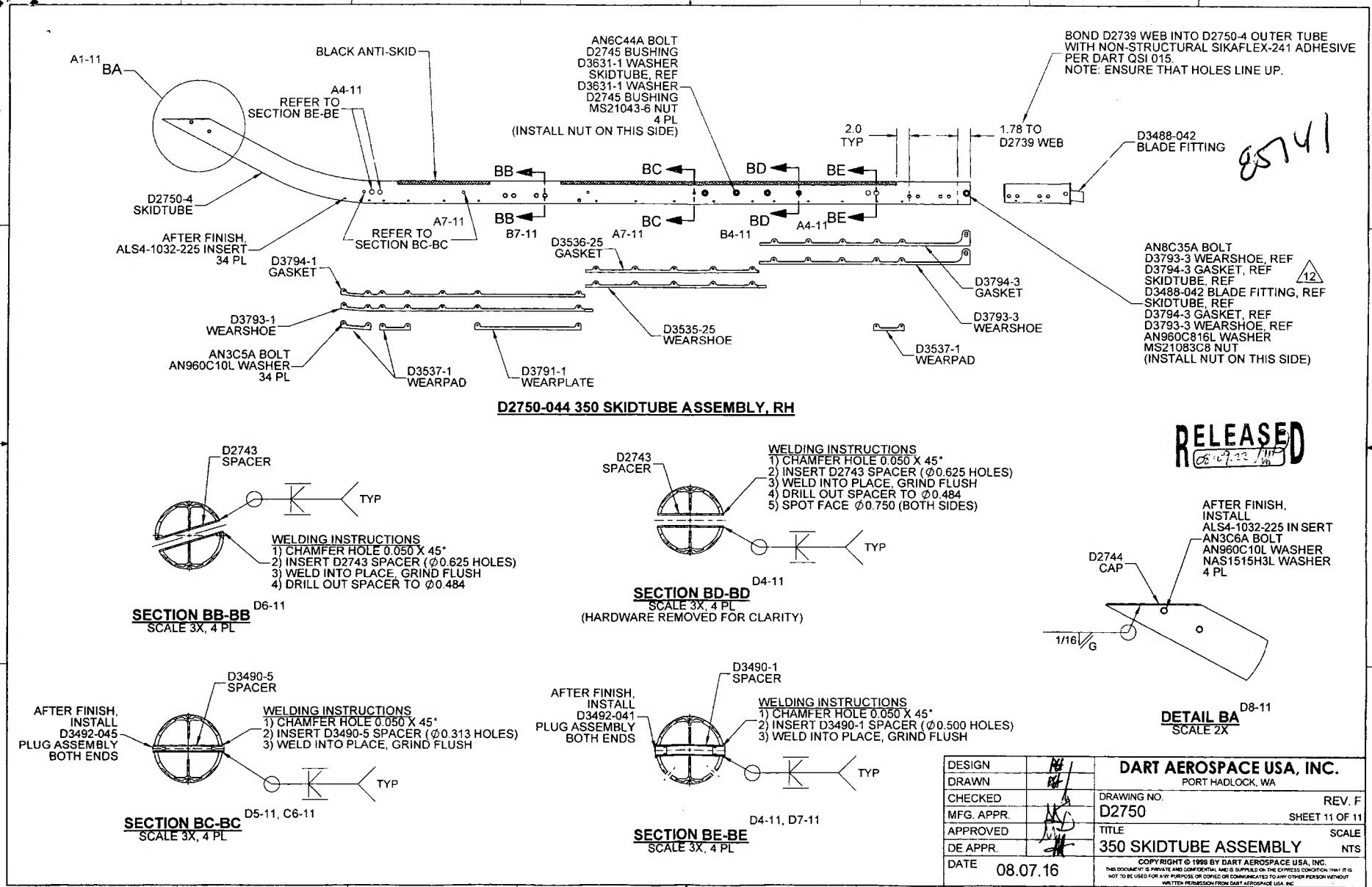
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NO. 294

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 83800  
Part number: 1350-636-012  
Description: Skidtuber  
Welding Process: Tig[✓] Mig[  ]  
Base materiel: Alum  
Current: AC[✓] DC[  ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[✓] fail[  ]  
Penetration: pass[✓] fail[  ]

UNACCEPTABLE

Cracks: pass[✓] fail[  ]  
Undercut: pass[✓] fail[  ]  
Pin holes: pass[✓] fail[  ]  
Overlap (cold lap) pass[✓] fail[  ]  
Porosity (surface): pass[✓] fail[  ]  
Coloration: pass[✓] fail[  ]

Qualifier Barclay Elliott Date of Test Coupon 2.05.09

Welder Barclay Elliott Date of Test Coupon 12.05.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld